

Date: Wednesday, 7/5/2006 2:48:30 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 350/212/130 BASKET LID						
Job Number	: 27815B									
Estimate Number	: 10193									
P.O. Number	: N/A		Part Number	: D2512						
This Issue	: 7/5/2006	S.O. No.	: N/A	Drawing Number	: D2512 REV D2					
Prsht Rev.	: NC			Project Number	: N/A					
First Issue	: N/A		Type	: LARGE FAB ASSY		Drawing Revision	: D2			
Previous Run	: 27578B			Material	: N/A					
Written By	: <u>See J. COMMENT Below</u>		Due Date	: 7/30/2006			Qty:	1	Um:	Each
Checked & Approved By	: <u>J. 06.07.05</u>									
Comment	: Rev Est:M 09.01.31 Added D2012-117 for D130-701-041 KJ/ RF Est Rev:N 06.04.05 Added level21		EC							

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
		
	Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)	
	Pick: 3/4"x3/4" 304/316 SS tube .063" wall Batch: M101309	PD 06-07-07
2.0	D31663	Basket Hoop
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
	Pick: Qty Part Number Description Batch 1 D3166-3 Basket Hoop B27327	PD 06-07-07
3.0	D2506	Placard
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
	Pick: Qty Part Number Description Batch 1 D2506 Label Plate B26631-2	PD 06-07-07
4.0	D23271	Spacer Bushing
		
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Pick: Qty Part Number Description Batch 2 D2327-1 Bushing B266742	PD 06-07-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 27815B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0 D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D2232-1 Hinge plate *B25233*

PD

06-07-07

6.0 D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D2581 Mounting Bracket *B27524*

PD

06-07-07

7.0 M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number Description

Batch

18 sf M304EX0.75-16F Expanded Metal *M101358*

PD

06-07-07

8.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

PD 06-07-07

9.0 QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

06/07/24 Q

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
*							

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

DQA: Date: 06/08/14

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

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Process Sheet

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Drawing Name: 350/212/130 BASKET LID

Job Number: 27815B

Part Number: D2512

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC 06/07/25 ①
BL

11.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

m101560 spray
Batch: m101667 wing walk FC @0726 ①

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/08/10 ①

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

14.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

① 06/08/14

Job Completion



C Log 06/08/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



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03NSIS

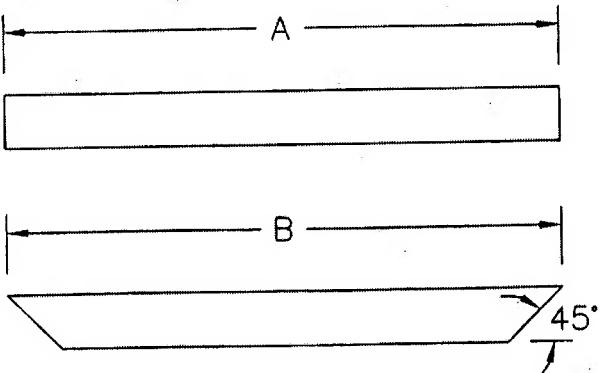
DESIGN BW	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D2512
DATE 01.04.19		REV. D SHEET 1 OF 4 TITLE SCALE NTS BASKET LID ASSEMBLY (350/212)

RELEASED
01.04.27 *CP*

A	95.11.21	NEW ISSUE
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074
D	01.04.19	CHANGE HINGE
D1	CP 03.01.20	ADD D2012-117 FOR D130-701-041
D2	CP 09.09.20	TACK WELD ANTI-SKID AREA

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING

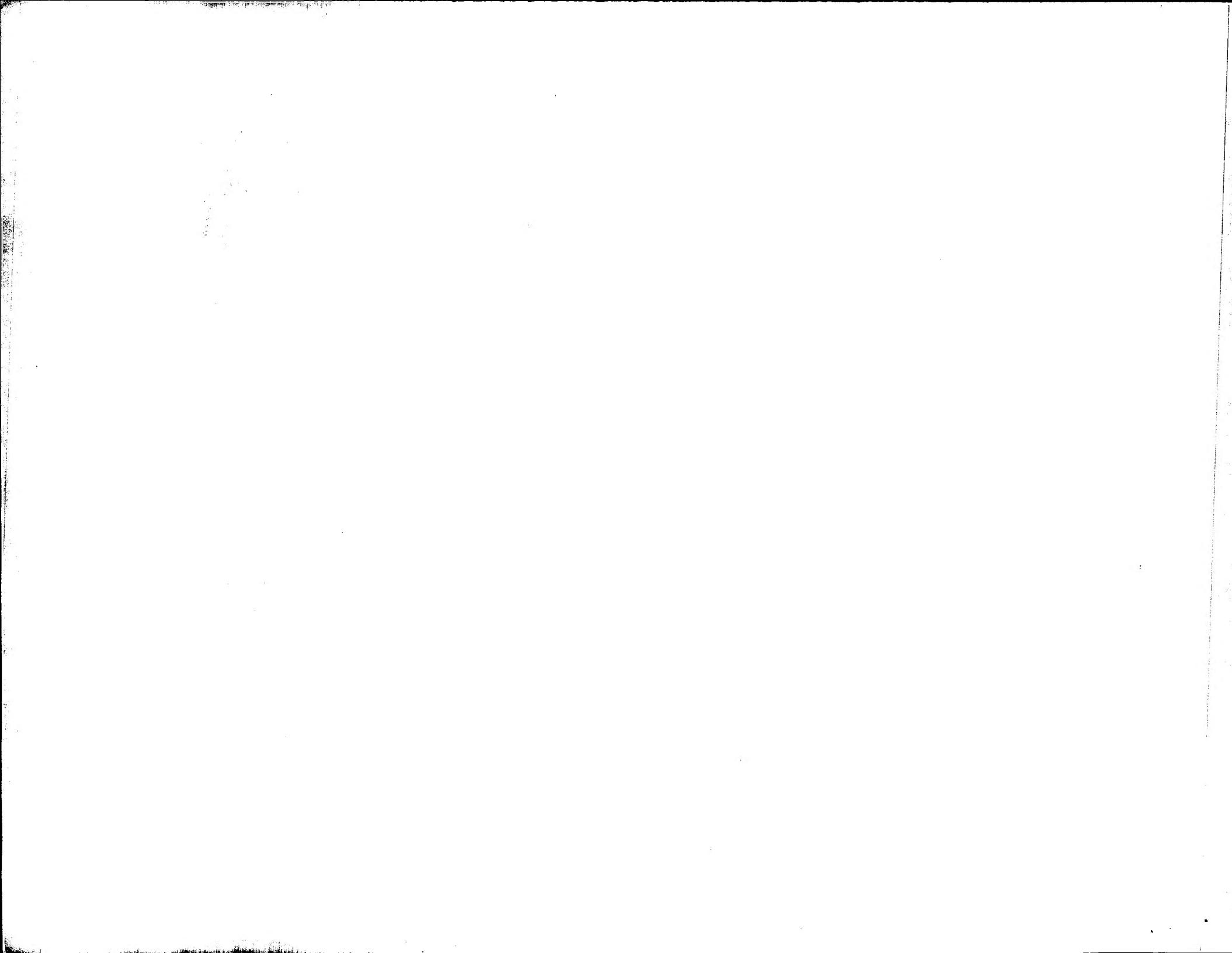
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

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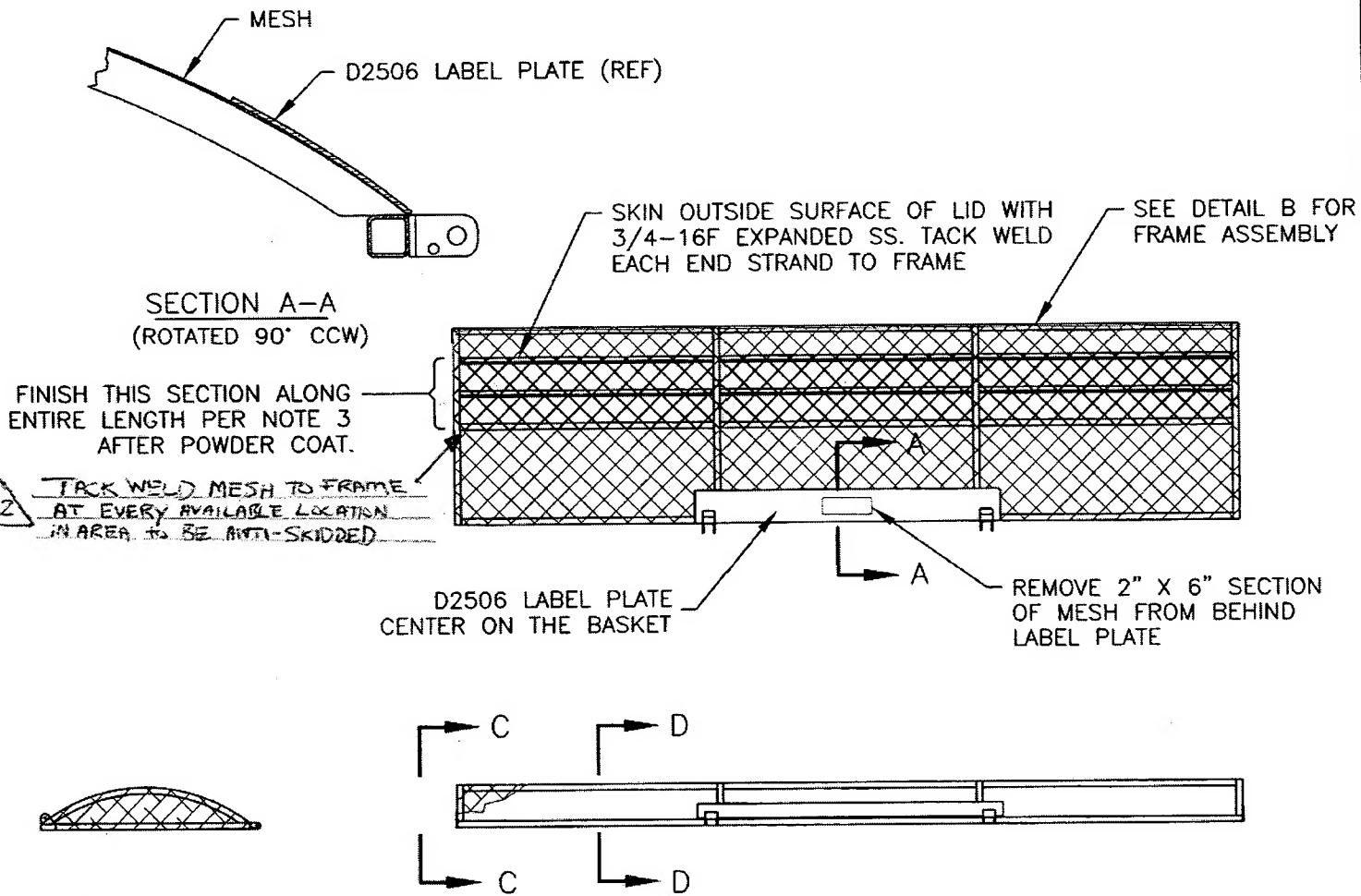
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WORK ORDER NO. 22816B

D2



D2512 BASKET LID ASSEMBLY

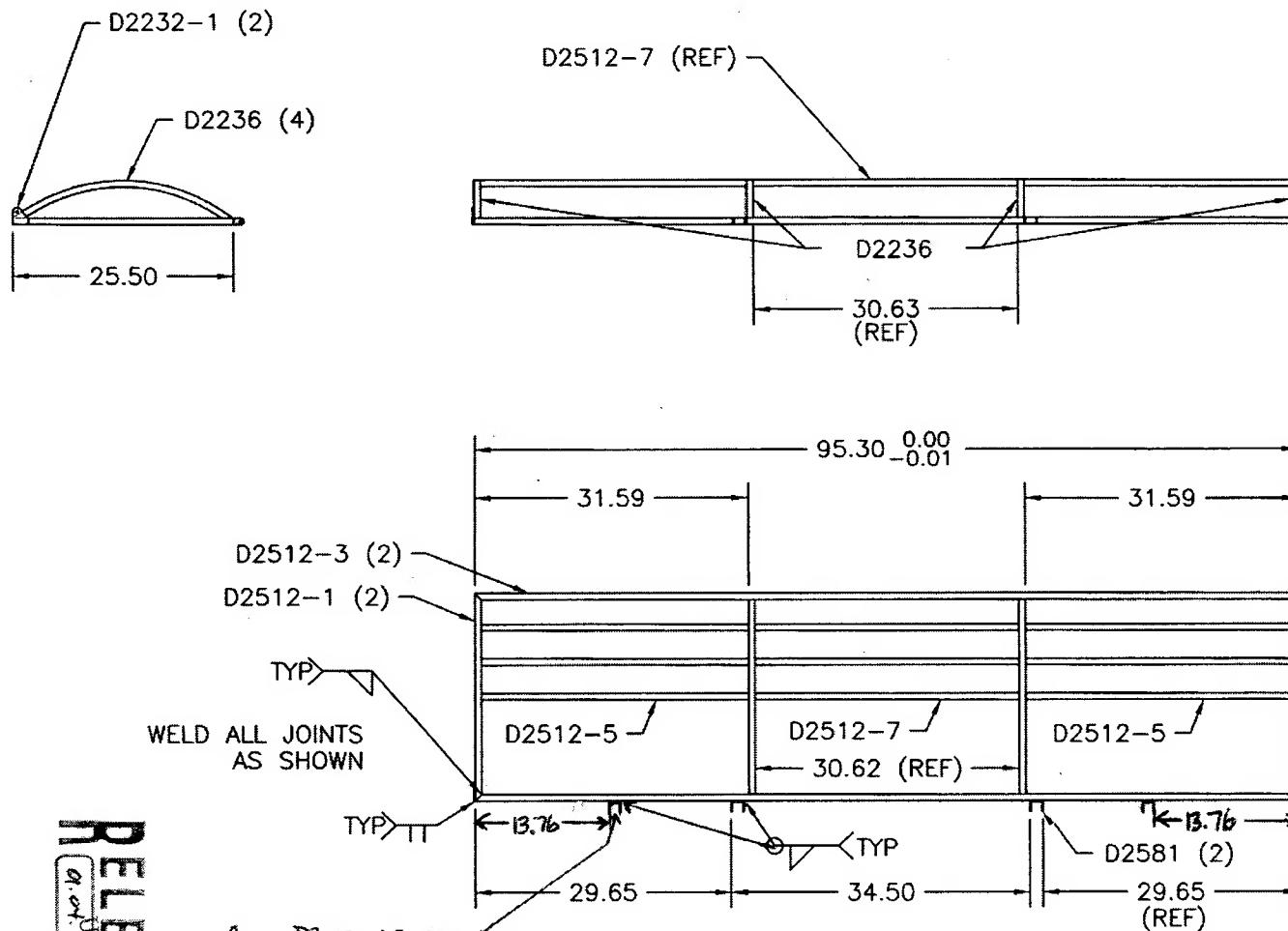
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

DART		DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD	
DESIGN BW	CHECKED <i>[Signature]</i>		DRAWING NO. D2512	HAWKESBURY, ONTARIO, CANADA
DATE 01.04.19	APPROVED <i>[Signature]</i>	TITLE BASKET LID ASSEMBLY (350/212)		SHEET 2 OF 4 1:20 SCALE

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DARTCOPY
SHEET 3 OF 4

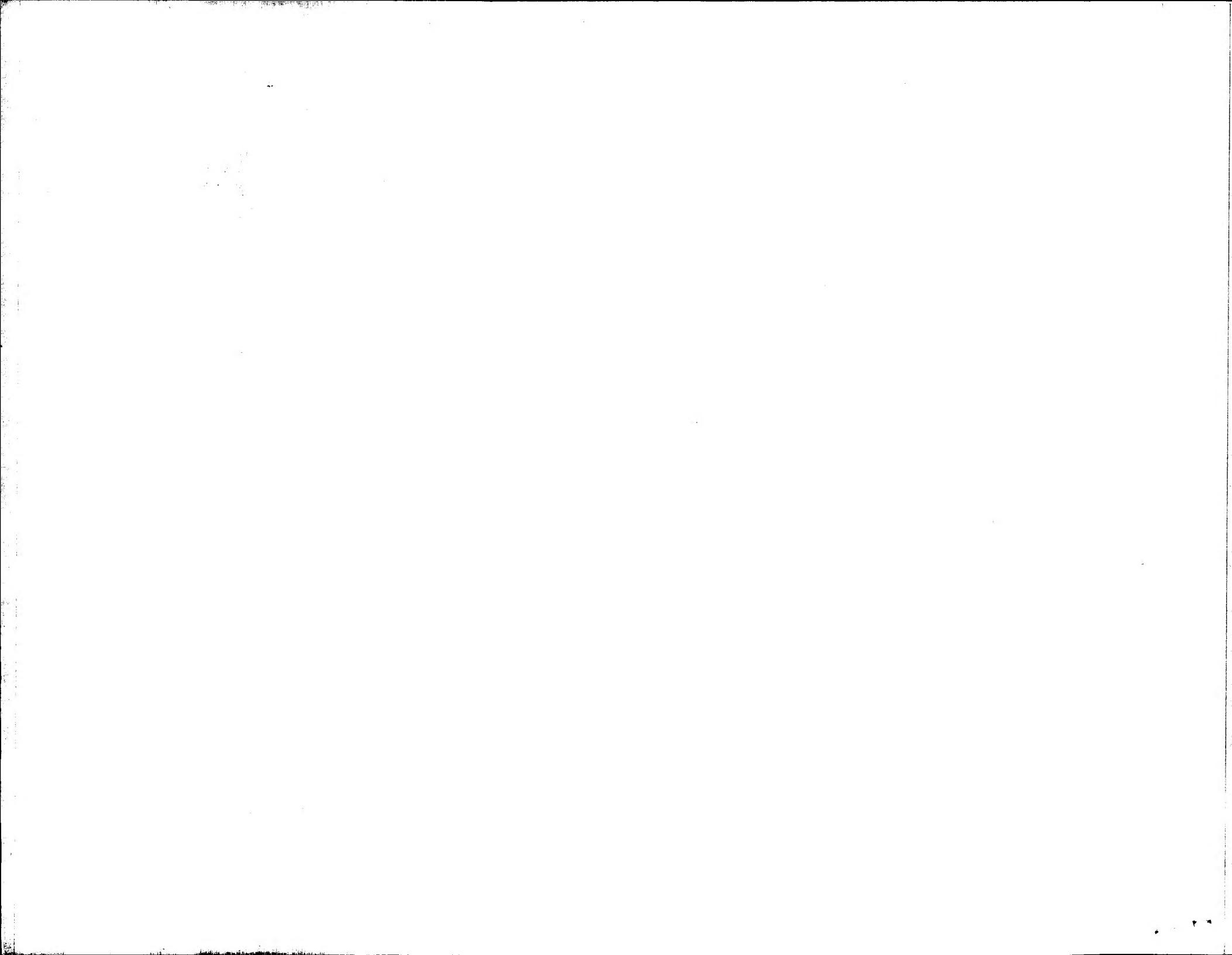
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CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D2512
DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)	REV. D SHEET 3 OF 4 SCALE 1:20

DETAIL B

FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

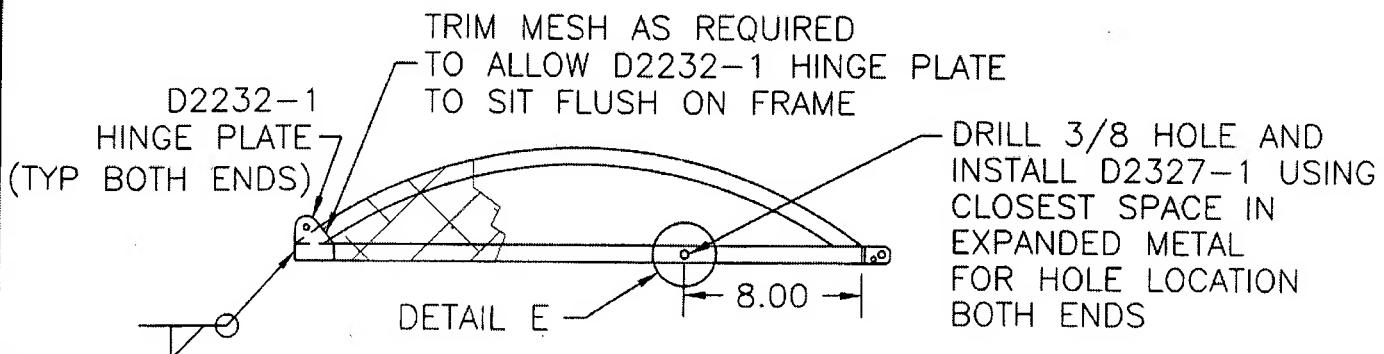
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27815-B

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DEPARTMENT
OR
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SUBJECT TO AMENDMENT
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NO. 27815-B

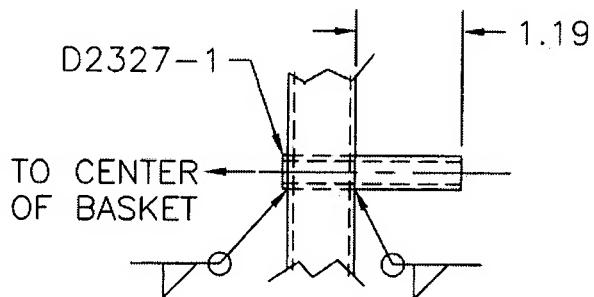


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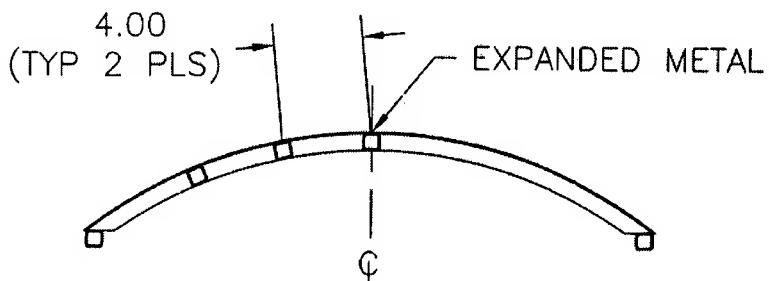
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8



SECTION C-C SIMILIAR BOTH END RIBS



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

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RELEASED
01.04.27
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